

Work Order ID 147877

Friday, June 17, 2016 8:24:23 AM

147877

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Item ID: D2939-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle RH In, 206

Start Date: 6/3/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/17/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00				4	0		32 9-89 / 16-06-31
130									
QC	Memo	0.01							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00				4	0		2016/09/31 BEB
140									
HandFinish	Memo	0.05							
Hand Finishing									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				4	0	1609-1	34 9-89
150									
Powdercoat	Memo	0.02							
Powder Coating									
	START TIME: 7:50								
	FINISH TIME: 8:20								

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Item ID: D2939-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle RH In, 206
Start Date: 6/3/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 6/17/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				(4)			DAS 38 SEP 07 2016
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>56395</u> Memo	0.00 0.01				4	DAS 6 9-39		SEP 08 2016
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.07					DAS 21 9-39		SEP 08 2016
							DAS 21 9-39		SEP 08 2016

Picklist Print

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Work Order ID: 147877

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Parent Item: D2939-2

D2939-2

Parent Item Name: Saddle RH In, 206

Start Date: 6/3/2016

Required Date: 6/17/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	37.0000	1	4			

D6101-001

Saddle Billet

B.a 16/08/28

Location

Loc Qty

Loc Code

MAT042

37

→ 145262

37

4.0

DART AEROSPACE LTD				Work Order: 147877	
Description: 206 Saddle, Inboard, Right side				Part Number: D2939-2	
Inspection Dwg: D2939 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

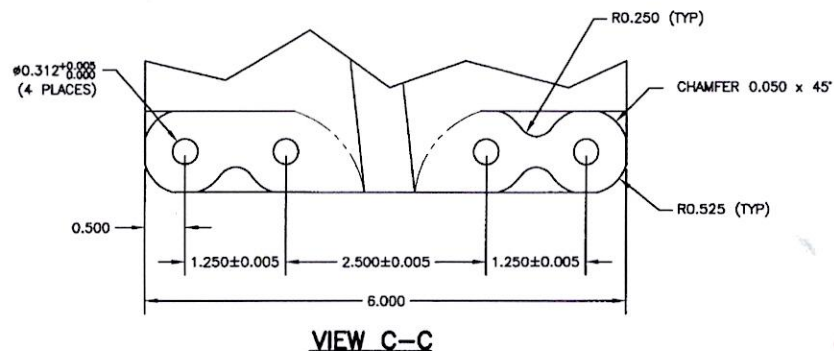
☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		0.125	0.114	0.114	0.113	
B	0.100	0.140		0.125	0.114	0.112	0.114	
C	0.100	0.140		0.125	0.112	0.112	0.112	
D	0.210	0.230		0.225	0.226	0.226	0.227	
E	1.245	1.255		1.250	1.250	1.250	1.250	
F	1.245	1.255		1.250	1.250	1.250	1.250	
G	2.495	2.505		2.500	2.500	2.500	2.500	
H	0.510	0.515		0.513	0.513	0.513	0.513	
I	1.572	1.582		1.577	1.577	1.577	1.577	
J	2.495	2.505		2.500	2.500	2.500	2.500	
K	0.257	0.262		0.258	0.258	0.258	0.258	
L	0.312	0.317		0.314	0.314	0.314	0.314	
M	0.235	0.240		0.236	0.238	0.238	0.238	
N	0.100	0.140		0.117	0.120	0.119	0.119	
O	0.540	0.560		0.547	0.549	0.548	0.548	
P	0.490	0.510		0.499	0.498	0.498	0.499	
Q	3.715	3.725		3.720	3.720	3.720	3.720	
R	2.720	2.760		2.740	2.740	2.740	2.740	
S	0.240	0.270		0.254	0.255	0.255	0.255	
T	0.100	0.180		0.130	0.130	0.130	0.130	
U	1.625	1.635		1.630	1.630	1.630	1.630	
V	1.362	1.372		1.367	1.367	1.367	1.367	
W	0.316	0.321		0.317	0.317	0.317	0.317	
X	1.250	1.270		1.260	1.260	1.260	1.260	
Y	1.565	1.585		1.575	1.575	1.576	1.576	
Z	0.178	0.198		0.180	0.180	0.180	0.180	
AA								
AB								
AC								
AD								

DAS Accept/Reject

Measured by: 33 / FK 16-08-30	Date: 16/08/29
Audited by: 32 16-08-30	Date:
Prototype Approval: 9-89 N/A	Date: N/A

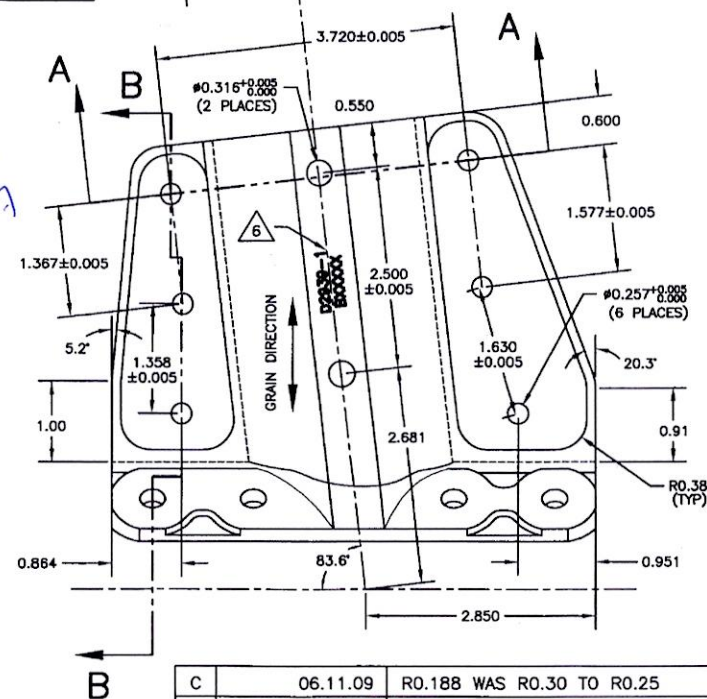
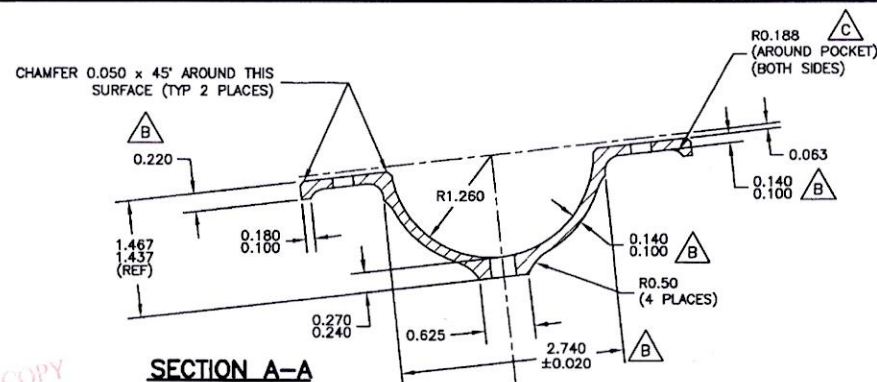
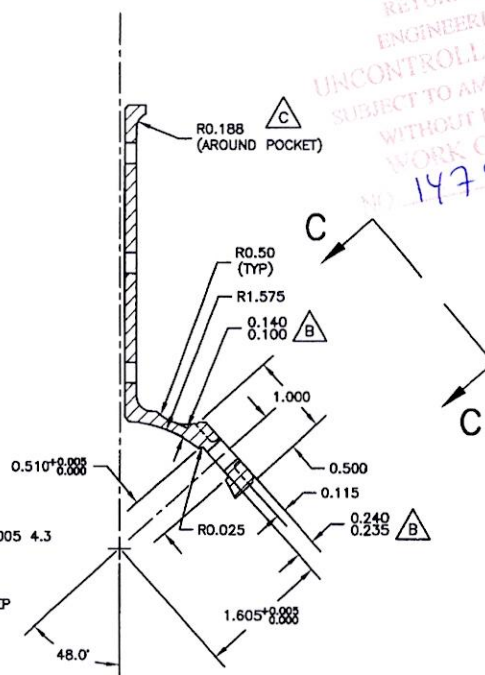
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	



D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

NOTES:

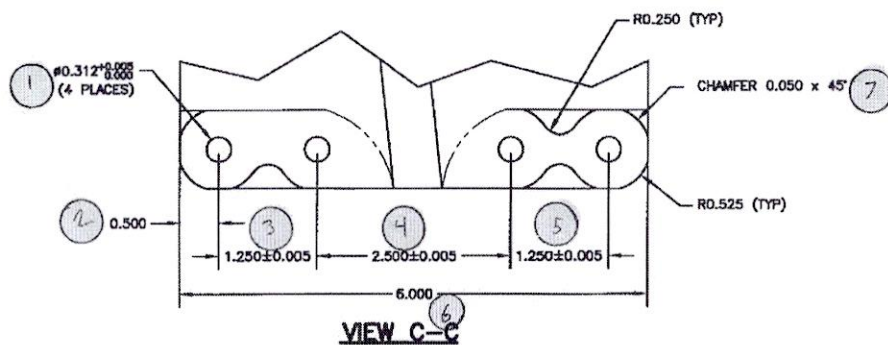
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO. D2939
DATE	06.11.09	TITLE SADDLE INSIDE
REV. C		SHEET 1 OF 1
		SCALE 2:3

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D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (00-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
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POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
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- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

